

Date: Wednesday, 12/11/2008 1:37:16 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BELT GUIDE
Job Number : 43354	
Estimate Number : 13015	
P.O. Number :	Part Number : D36401
This Issue : 12/11/2008 S.O. No. :	Drawing Number : D3640 REVA
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 42131	Material :
Written By :	Due Date : 21/11/2008 Qty: 10 Um: Each
Checked & Approved By : <u>JUD 08.11.12</u>	
Comment : Est Rev:A New Issue 07-01-15 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MDELRLNB075X1250	Delrin Bar
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Comment: Qty.: 0.4200 f(s)/Unit Total : 4.2000 f(s)

Black Delrin Bar

1.250" X .750"

BATCH: M100724mf 08/11/13

(10)

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: Cut blank 4.700 " long

mf 08/11/13

(10)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA670 & Dwg D3640 Rev: A

2-Deburr and Blend rad intersection with deburring tool.

mf 08/11/13

(10)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mf 08/11/13

(10)

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

H.A 08/11/13

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/11/2008 1:37:16 PM
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Drawing Name: BELT GUIDE

Job Number: 43354

Part Number: D36401

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

57261

Pc 8/11/15 (10)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/2019

Job Completion



MC 08-11-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 43354
Description: Belt Guide		Part Number: D3640-1
Inspection Dwg: D3640	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.50	+/-0.030	4.500	/			
0.80	+/-0.030	0.800	/			
0.13	+/-0.030	0.130	/			
0.31	+/-0.030	0.310	/			
0.200	+/-0.010	0.200	/			
0.40	+/-0.030	0.393	/			
0.03 x 45°	+/-0.030 x 0.5°	0.045 x 45°	/			
0.23	+/-0.030	0.219	/			
0.40	+/-0.030	0.400	/			
0.625	+/-0.010	0.632	/			
R0.13	+/-0.030	R.130	/			

Measured by: JMF	Audited by: H.A	Prototype Approval: N/A
Date: 08/11/13	Date: 08/11/18	Date: N/A

Rev	Date	Change	Revised by	Approved
A	07.10.19	New Issue	KJ/EC/DD	[Signature]

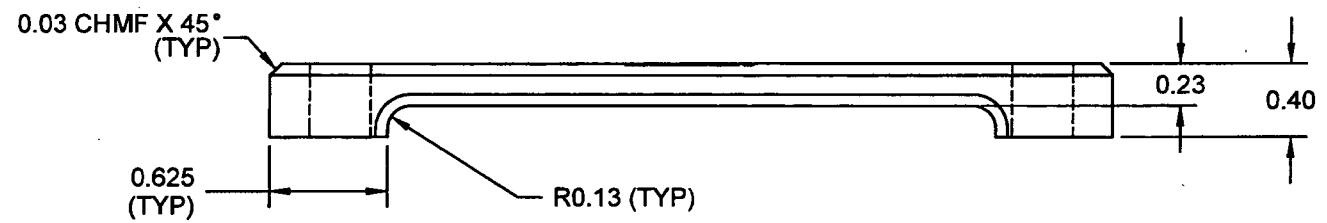
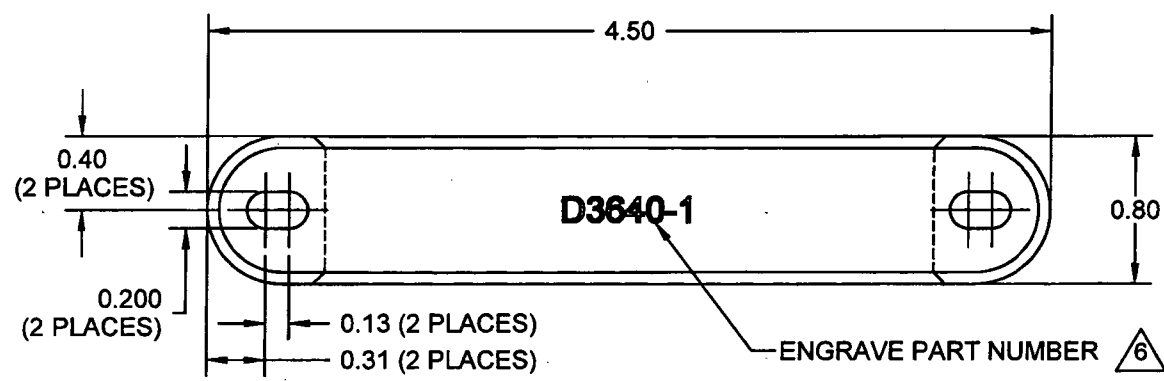
8 7 6 5 4 3 2 1

D

C

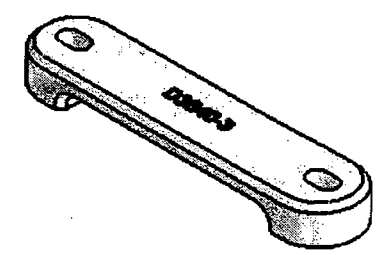
B

A



D3640-1 BELT GUIDE
(WAS GENEVA P/N G10605-1)

- NOTES:
- 1) MATERIAL: BLACK DELRIN II 150E OR ACETRON GP ACETAL BAR (REF DART SPEC M-DELRIN-B)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: ENGRAVE PART NUMBERS TO MAX DEPTH OF 0.010 AT LOCATIONS SHOWN
 - 7) WEIGHT: 0.03 lbs

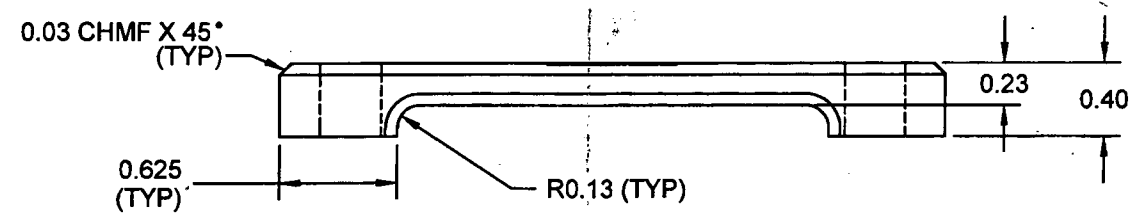
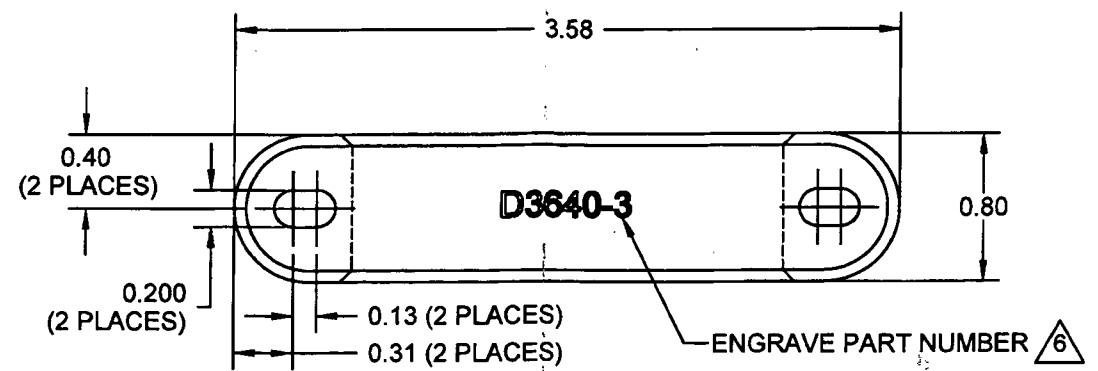


D

C

B

A



D3640-3 BELT GUIDE
(WAS GENEVA P/N G10605-2)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 43354-
RELEASED
07.07.27

A	NEW ISSUE; REPLACES G10605		LE	07.07.27
REV.	DESCRIPTION		BY	DATE
DESIGN	TS	DART AEROSPACE USA, INC. PORT HADLOCK, WA		
DRAWN	LE			
CHECKED	LE	DRAWING NO.	REV. A	
MFG. APPR.	LE	D3640	SHEET 1 OF 1	
APPROVED	LE	TITLE	SCALE	
DE APPR.	LE	BELT GUIDE	1:1	
DATE	07.07.27		COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	